

Date: Thursday, 3/13/2008 10:20:34 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 37932-2  
 Estimate Number : 10425  
 P.O. Number :  
 This Issue : 3/13/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 37886  
 Written By :  
 Checked & Approved By :  
 Comment : Est. A 04.04.19 New issue KJ/JLM  
 ESR B 06.05.25 Waterjet EC

Drawing Name : PLATE

Part Number : D32191  
 Drawing Number : D3219 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 4/25/2008

Qty: 40 Um: Each

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet

Comment: Qty.: 0.1012 sf(s)/Unit Total : 4.0488 sf(s)

6061-T6 .125 Sheet

To be made in multiples of 4

Material: 6061-T6 (QQ-A-200/11) 0.125" thick

(M6061T6S.125) Batch: 105646 B 8-3-17

2.0 WATER JET FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3219

Dwg Rev: A

Prog Rev: A

B 8-3-17

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1

Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3219-1 PAR #: N/A Fault Category: Problems associated with small water jet. NCR: Yes No DQA: LD Date: 08/04/04  
D350-51 QA: N/C Closed: LD Date: 08/04/04

NCR: <u>37932</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/04/04</u>	<u>20</u>	<u>3 parts found with knuckles from the water jet.</u>	<u>[Signature]</u> <u>08/04/04</u>	<u>Scrap and Destroy</u> <u>No Replace.</u> <u>Qty <u>(+3)</u></u>	<u>JB</u> <u>8-4-1</u>	<u>[Signature]</u> <u>08/04/04</u>	<u>[Signature]</u> <u>08/04/04</u>	

NOTE: Date & initial all entries



Date: Thursday, 3/13/2008 10:20:34 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 37932

Part Number: D32191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-02  
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

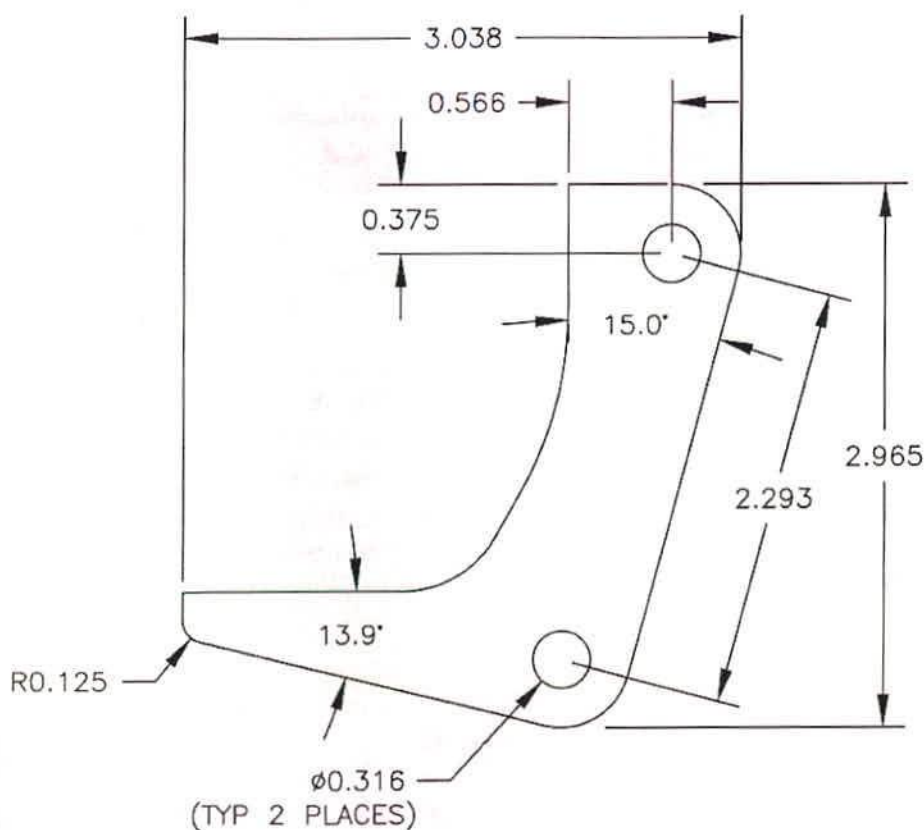






DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED  
04.04.05 *[Signature]*



#### D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRF"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)  
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37932

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.